

**\*83918\***

Page 1

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 27/04/2012    **Start Qty:** 8.00    **\*g\***

**Cust Item ID:**

**Required Date:** 11/05/2012      **Req'd Qty:** 8.00      **\*O\***

**Customer:**

**Reference:**

Approvals: Process Plan: MLJ Date: 12/04/27

### Tooling:

Date:

Run Start \*NR1\*

QC: \_\_\_\_\_ Date:    /    /    SPC (Y/N): \_\_\_\_\_

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>					(24)			
D3208	C								
100		0.00							
<b>*100*</b>	SHEAR								
Waterjet	<b>Memo</b>	0.00							B12-5-14
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>E</u> Prog Rev: <u>E</u> 2-Deburr if necessary								
110		0.00							
<b>*110*</b>	QC2- Inspect parts off machine FAI/FAIB								
QC	Small Fab								
Quality Control	<b>Memo</b>	0.00							B12-5-14
120		0.00							
<b>*120*</b>	QC8- Inspect parts - second check								
QC									
Quality Control	<b>Memo</b>	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83918

April-27-12 11:20:32 AM

**\*83918\***

Page 2

Item ID: D3208-7

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Filler

Start Date: 27/04/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 11/05/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

**\*130\***

HandFinish

Memo

0.00

Hand Finishing

24 26/12-5-23

140

QC7-Inspect Chemical Conversion Coat

0.00

**\*140\***

QC

Memo

0.00

Quality Control

24 d BL 12-5-23

150

Identify as per dwg & Stock Location: 51202

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

24 5/12/5/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 83918**

April-27-12 11:20:32 AM

**\*83918\***

Page 3

Item ID: D3208-7

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Filler

Start Date: 27/04/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 11/05/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

12/5/25  
MLC 12/05/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April-27-12 11:20:36 AM

Page 1

Work Order ID: 83918

\*83918\*

Parent Item: D3208-7

\*D3208-7\*

Parent Item Name: Filler

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: B04.05.25Material changed for Step 4KJ/JLM IPP REV  
C:PER REV B 12-03-23 JLM VERIFIED BY:EC IPP REV:D  
12.04.20 as per dwg rev.C DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased		No			sf	556.2800		0.759579	7.5		
*M6061T6S 080*										**			
6061-T6 .080 Sheet													

Location	Loc Qty	Loc Code
MAT021	556.28	
117285	2.15	
119766	39.6	
120096	311.13	
120349	11.4	
121193	192	

121193

11/12-5-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

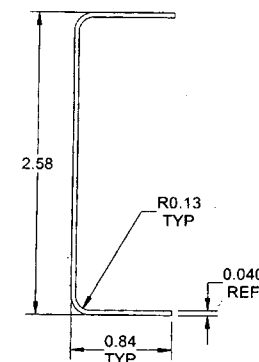
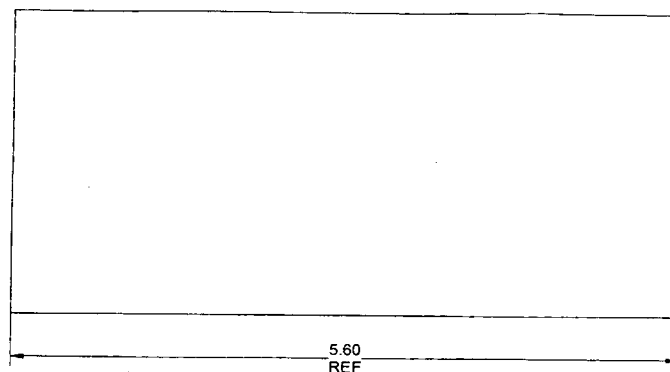
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83918 MCLJ  
12/04/27

RELEASED  
R 2012-04-10

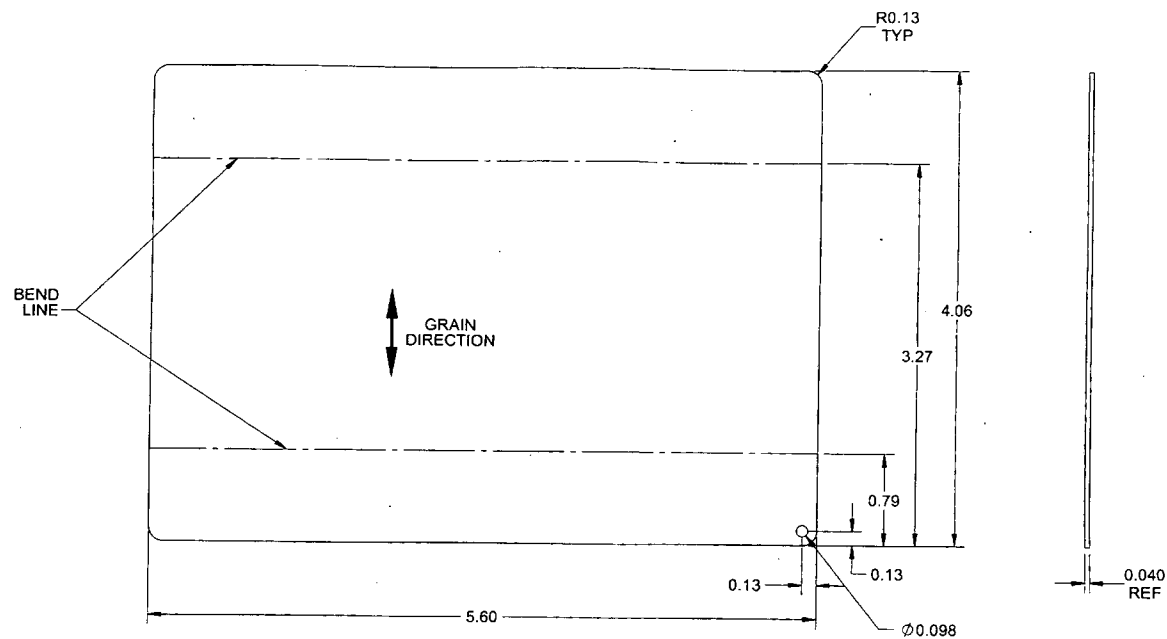
# **D3208-1 DOUBLER**

## **NOTES:**

- 1) MATERIAL: MAKE FROM D3208-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.09 lbs

C	REVISE NOTE 1) (ZN A8-7); 0.080 WAS 0.040 (ZN B3-7)	RF	12.04.12
B	CONVERT DRAWING TO STANDARD FORMAT, RE-DESIGN D3208-1 (ZN B5-1, B5-2); RE-DESIGN D3208-7 (B5-7); CHANGE TO 2 DEC. PLACES (ZN B5-4, C7-4, C3-6, B4-6, C6-6, D5-8, C6-8, B5-8; ADD HOLE TO D3208-9 ZN (B4-8); 1.50 WAS 1.250 (ZN C4-9) PER PART 12-162	RF	12.02.24
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	<b>D3208</b>	SHEET 1 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>DOUBLER</b>	NTS
DATE	12.04.12	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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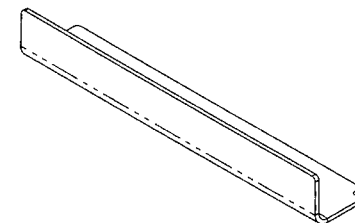
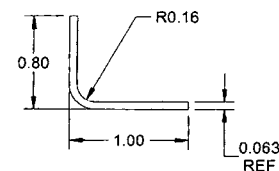
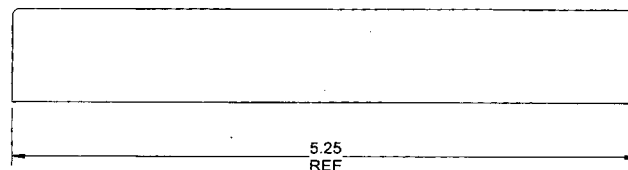
**D3208-1F DOUBLER FLAT PATTERN**

RELEASED  
2012-04-18

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037 OR ASTM B209  
REF DART SPEC M2024T3S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3208	SHEET 2 OF 9
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**D3208-3 PEDAL MOUNT ANGLE**

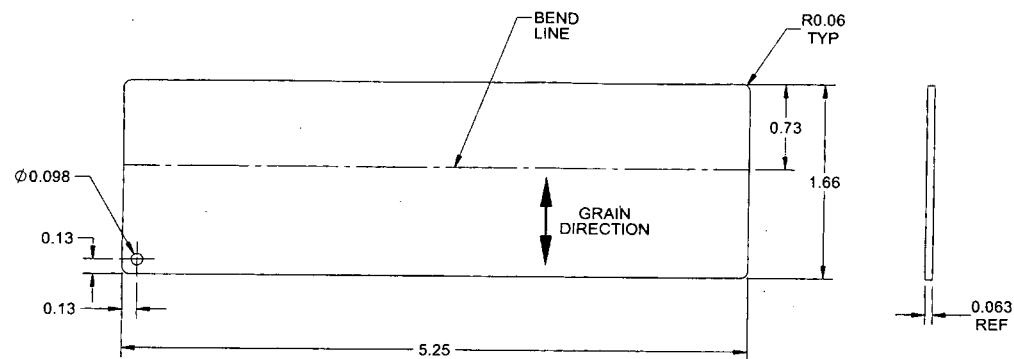
RELEASED  
2012-04-18  
JW

**NOTES:**

- 1) MATERIAL: MAKE FROM D3208-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3208	SHEET 3 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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**D3208-3F PEDAL MOUNT ANGLE FLAT PATTERN**

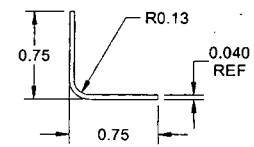
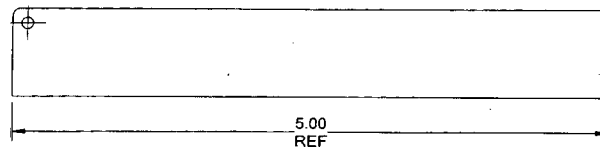
RELEASED  
2012-04-18

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037 OR ASTM B209  
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3208	SHEET 4 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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**D3208-5 MOUNT ANGLE**

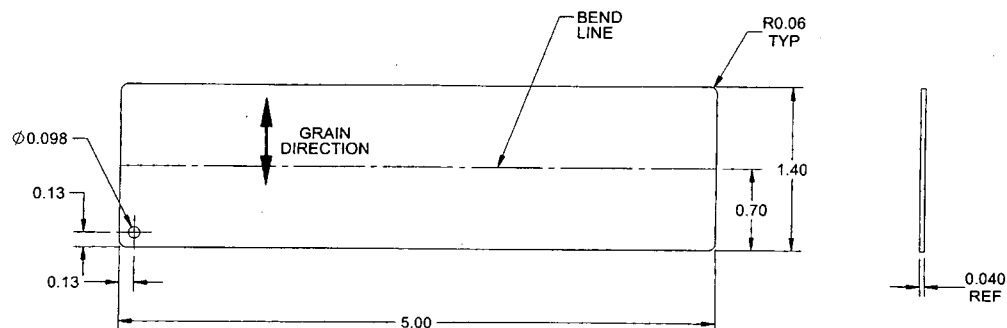
RELEASED  
2012-04-18  
MD

**NOTES:**

- 1) MATERIAL: MAKE FROM D3208-5F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3208	SHEET 5 OF 9
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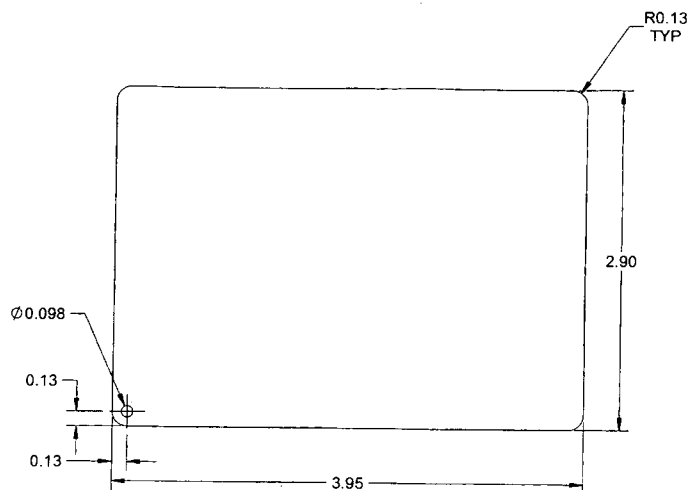
**D3208-5F MOUNT ANGLE FLAT PATTERN**

RELEASED  
2012-04-18  
JW

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037 OR ASTM B209  
REF DART SPEC M2024T3S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3208	SHEET 6 OF 9
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**D3208-7 FILLER**



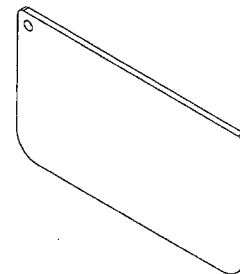
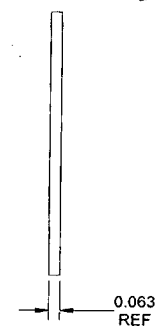
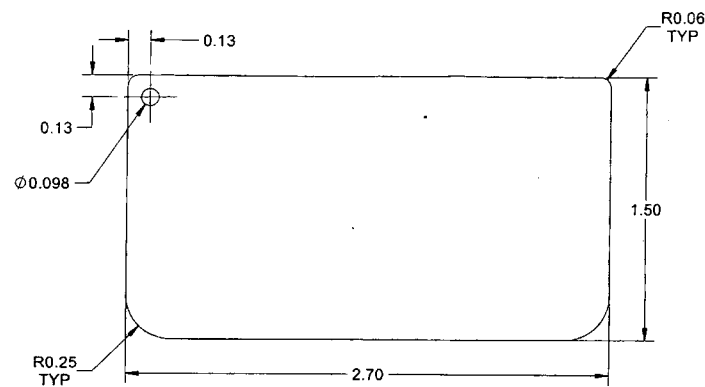
**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.080 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.09 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3208	SHEET 7 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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2012-04-18  
*[Signature]*



83918

# **D3208-11 FILLER**

REF 2012-04-18

## **NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3208</b>	REV. C
MFG. APPR.	<i>[Signature]</i>		SHEET 9 OF 9
APPROVED	<i>[Signature]</i>	TITLE <b>DOUBLER</b>	SCALE
DE APPR.	<i>[Signature]</i>		NTS
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